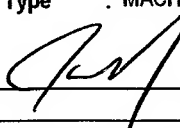


Date: Thursday, 05/06/2008 1:09:40 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 39725		
Estimate Number	: 12322		
P.O. Number	:	Part Number	: D3492041
This Issue	: 05/06/2008 S.O. No. :	Drawing Number	: D3492 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 39676	Material	:
Written By	: 	Due Date	: 12/06/2008 Qty: 100 Um: Each
Checked & Approved By	:		
Comment	: est rev A 06.03.03 New Issue EC		
	: Est Rev:B 06-08-28 As per Rev B JLM		
	: Est Rev:C 07-12-06 Rev C dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0625	6061-T6 Round Bar .625"
-----	--------------	-------------------------



(100)



Comment: Qty.: 0.0656 f(s)/Unit Total : 6.5625 f(s)
 6061-T6 Round Bar .625"
 (M6061T6R0625)
 Batch: MK75B

J.F. /mmf 08/06/07

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 & Dwg D3492
 Dwg Rev: B
 Folio Rev: 2AA

(100)

J.F. /mmf 08/06/07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(100)

J.F. /mmf 08/06/07

(100)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. /mmf 08/06/07

(100)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if neccesary
 2-Tumbler

08/06/09 100 Jm
 08/06/12 100 comitel

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39725

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(100)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/06/13

7.0

POWDER COATING

POWDER COATING



M107925



(100x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:15 p.m.
320 °F
2:45 p.m.

M-1 08/06/16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-16 (X100)

9.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-010 O-RING

(or MS28775-010)

M106533 (40x)
M100539 (60x)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

1- Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch:

M101223

08-06-17

(X100)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/18 (X100)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-1

YH

08-16-17

(X100)

Date: Thursday, 05/06/2008 1:09:40 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39725

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/19 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Lu 08-06-18

DART AEROSPACE LTD		Work Order:	39725
Description: Plug		Part Number:	D3492-1
Inspection Dwg: D3492	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

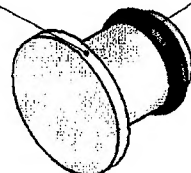
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060"	✓			
0.060	+/-0.005	.059"	✓			
Ø0.394	+/-0.010	Ø.395"	✓			
Ø0.625	+/-0.010	Ø.622"	✓			
0.090	+0.000/-0.002	.089"	✓			
0.500	+/-0.010	.499"	✓			
0.055	+0.000/-0.002	.055"	✓			
.050" x 20°	± .010"	.040"	✓			

Measured by: J.F.	Audited by: RD	Prototype Approval:	N/A
Date: 08/06/06	Date: 08/06/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD	

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



w/ 39725

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
			1				NAS1611-016	O-RING

△ △ △

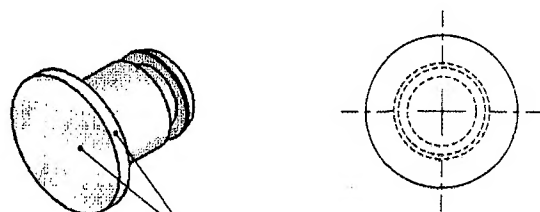
NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

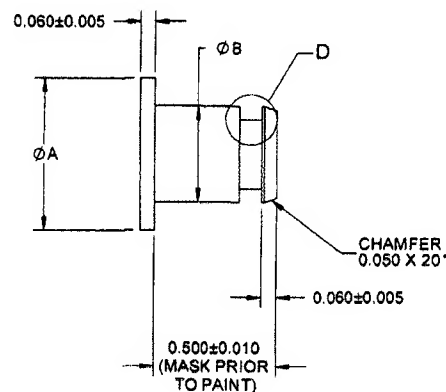
-041
-051
06.06.05
UNDER REVIEW
01.07.21
DIM 0.00 IN D3492-13
REVISION (WHICH SMALLER)
RELEASED
07.10.05

C	ADD -049/-051/-053. CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047. UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	08.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

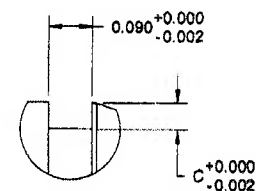
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3492	REV. C
TITLE PLUG	SHEET 1 OF 2
SCALE 2:1	
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POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-8	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.860	0.684	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3492 TITLE PLUG SCALE 4:1 SHEET 2 OF 2 REV. C DATE 07.10.05
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS APPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

RELEASED
07.11.16

-041
RD 08-06-05
UNDER REVIEW
01.04.12/BA
DIM 08 PER D3492-13
REV. C (TWICE SMALLER)

52168 01/03/05